

137562

Page 1

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 10/6/2015 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 10/20/2015 **Req'd Qty:** 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: SA Date: 20151006 To: _____

Tooling:

Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____

Date: _____

Stop *NR2*

[illegible]

Work Order ID 137562

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Page 2

Item ID: D4030-043 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Long Basket Assembly, Light Lid (350)
Start Date: 10/6/2015 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 10/20/2015 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

Identify as per dwg & Stock Location: _____

0.00

130

Packaging

Memo

PPP 13722 0.00

SMB
15/12/16

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

ML5

DEC 17 2015

ML5

DEC 17 2015

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Work Order ID: 137562

137562

Parent Item: D4030-043

D4030-043

Parent Item Name: Long Basket Assembly, Light Lid (350)

Start Date: 10/6/2015

Required Date: 10/20/2015

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue DD 10.03.23 verified by:EC IPP Rev:B as
per dwg revB DD 10.04.20 verified by:EC IPP Rev:C added
NAS1149F0332P & NAS1149C0432R 10.06.16 DD
VERF:EC IPP Rev:D as per
dwg revC DD 10.08.18 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2530 *D2530* Handle Weldment		Manufactured	No			100	Each	5.0000	1	1			
** 137880													
Location ST379 134277 136095 Loc Qty 5 4 1 Loc Code													
D2535 *D2535* Spring		Manufactured	No			100	Each	27.0000	2	2			
** 137537													
Location ST008 134782 Loc Qty 27 27 Loc Code													
D2537 *D2537* Bushing		Manufactured	No			100	Each	22.0000	2	2			
** 135835													
Location ST008 132664 134935 Loc Qty 22 2 20 Loc Code													
D3913-041 *D3913-041* Long Basket Base Assembly, 350		Manufactured	No			100	Each	0.0000	1	1			
** 137824 (k) JDD v12/1/16													

DWG
6
9-59

DWG
6
9-59

DWG
6
9-59

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Work Order ID: 137562

137562

Parent Item: D4030-043

D4030-043

Parent Item Name: Long Basket Assembly, Light Lid (350)

Start Date: 10/6/2015

Required Date: 10/20/2015

Start Qty: 1.00

Required Qty: 1.00

D3915-041

Manufactured No

100 Each

0.0000

1 1

D3915-041

Light Lid Assembly, Long Basket

D3917-3

Manufactured No

100 Each

5.0000

6 6

D3917-3

Washer

**

13137563 (w) 10/12/15

**

138298

Location

Loc Qty

Loc Code

ST058

4

128455

4

ST065

1

121801

1

D3953-3

Manufactured No

100 Each

8.0000

2 2

D3953-3

Gas Spring Stud, Lid

**

136645

Location

Loc Qty

Loc Code

ST0062

8

122668

2

131080

6

D3953-7

Manufactured No

100 Each

42.0000

2 2

D3953-7

Spring Spacer

**

Location

Loc Qty

Loc Code

ST062

24

130996

12

131859

12

ST064A

18

135499

8

137212

10

DEC / 5 2015

2

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Shop Packet Print

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Page 3

Work Order ID: 137562

137562

Parent Item: D4030-043

D4030-043

Parent Item Name: Long Basket Assembly, Light Lid (350)

Start Date: 10/6/2015

Required Date: 10/20/2015

Start Qty: 1.00

Required Qty: 1.00

D3953-9

Manufactured No

100 Each 65.0000 2 2

D3953-9

Gas Spring Washer

Location

Loc Qty

Loc Code

ST064A

45

135544

45

ST069

20

131057

18

132672

2

2

D3953-17

Manufactured No

100 Each 10.0000 2 2

D3953-17

Gas Spring Spacer

136487

Location

Loc Qty

Loc Code

ST062

10

129797

10

D3953-19

Manufactured No

100 Each 22.0000 1 1

D3953-19

Gas Spring Bracket

Location

Loc Qty

Loc Code

ST062

22

131776

12

136464

10

D3953-21

Manufactured No

100 Each 38.0000 1 1

D3953-21

Gas Spring Bracket

Location

Loc Qty

Loc Code

ST063

38

128883

10

132602

28

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Work Order ID: 137562

137562

Parent Item: D4030-043

D4030-043

Parent Item Name: Long Basket Assembly, Light Lid (350)

Start Date: 10/6/2015

Required Date: 10/20/2015

Start Qty: 1.00

Required Qty: 1.00

D3969-3 Manufactured No

100 Each 25.0000 1 1

D3969-3

Prop

Location Loc Qty Loc Code

ST365 25
115924 5
135397 10
136918 10

AN3-14A Purchased No

100 Each 74.0000 4 4

AN3-14A

Bolt

Location Loc Qty Loc Code

ST348 74
m132825 74

AN3-20A Purchased No

100 Each 33.0000 2 2

AN3-20A

Bolt

Location Loc Qty Loc Code

ST348 33
117441 33

AN4-12 Purchased No

100 Each 49.0000 3 3

AN4-12

Bolt

Location Loc Qty Loc Code

ST325A 3
m128813 3
ST344 46
m132317 46

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Page 5

Work Order ID: 137562

137562

Parent Item: D4030-043

D4030-043

Parent Item Name: Long Basket Assembly, Light Lid (350)

Start Date: 10/6/2015

Required Date: 10/20/2015

Start Qty: 1.00

Required Qty: 1.00

AN5-17A

Purchased

No

100

Each

114.0000

2

2

AN5-17A

Bolt

**

133577

2-59

Location

Loc Qty

Loc Code

GA

36

117872

36

ST299A

50

m133077

50

ST337

28

m132317

28

AN5-21A

Purchased

No

100

Each

40.0000

2

2

AN5-21A

Bolt

**

2-59

Location

Loc Qty

Loc Code

ST337

40

M126175

15

M130466

25

AN310-4

Purchased

No

100

Each

79.0000

3

3

AN310-4

Nut

**

2-59

Location

Loc Qty

Loc Code

GA

25

M127815

25

ST331

54

M132382

54

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3

Picklist Print

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Work Order ID: 137562

137562

Parent Item: D4030-043

D4030-043

Parent Item Name: Long Basket Assembly, Light Lid (350)

Start Date: 10/6/2015

Required Date: 10/20/2015

Start Qty: 1.00

Required Qty: 1.00

AN310C4

Purchased

No

100

Each

66.0000

2

2

AN310C4

Nut

Location

Loc Qty

Loc Code

ST331

66

M131305

2

M132344

44

M133234 7

20

MS21042L3

Purchased

No

100

Each

850.0000

6

6

MS21042L3

Nut

Location

Loc Qty

Loc Code

FP001

334

M130922

334

GA

157

M131317

157

ST305

359

116549

12

126333

49

M128754

2

M132123

17

M132382

2

M132883

17

M133134

260

DEC 15 2015

Picklist Print

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Work Order ID: 137562

137562

Parent Item: D4030-043

D4030-043

Parent Item Name: Long Basket Assembly, Light Lid (350)

Start Date: 10/6/2015

Required Date: 10/20/2015

Start Qty: 1.00

Required Qty: 1.00

MS21042L5

Purchased

No

100

Each

374.0000

4

4

MS21042L5

133363

Nut

Location

Loc Qty

Loc Code

GA

146

m127813

146

ST305

228

m127813

19

m131340

21

m132123

8

m132677

180

MS24665-151

Purchased

No

100

Each

142.0000

3

3

MS24665-151

Cotter Pin

Location

Loc Qty

Loc Code

GA

59

m128401

59

ST294

83

m128401

9

m129909

74

MS24665-300

Purchased

No

100

Each

127.0000

2

2

MS24665-300

COTTER PIN

Location

Loc Qty

Loc Code

GA

30

118234

30

ST293

97

M128812

97

DEC 15 2015

2

Picklist Print

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Work Order ID: 137562

137562

Parent Item: D4030-043

D4030-043

Parent Item Name: Long Basket Assembly, Light Lid (350)

Start Date: 10/6/2015

Required Date: 10/20/2015

Start Qty: 1.00

Required Qty: 1.00

NAS1149F0432P

Purchased

No

100

Each

1,176.000

6

6

NAS1149F0432P

WASHER

Location

Loc Qty

Loc Code

ST260a

500

M132551

500

st268

676

M128995

63

M130388

8

M132677

125

M133234

480

NAS1149F0563P

Purchased

No

100

Each

93.0000

4

4

NAS1149F0563P

Washer

Location

Loc Qty

Loc Code

ST267

13

121350

13

st268

80

m132344

80

DEC / 5 2015

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Work Order ID: 137562

137562

Parent Item: D4030-043

D4030-043

Parent Item Name: Long Basket Assembly, Light Lid (350)

Start Date: 10/6/2015

Required Date: 10/20/2015

Start Qty: 1.00

Required Qty: 1.00

NAS1149F0332P

Purchased

No

100

Each

2,007.000

8

8

NAS1149F0332P

133709

Washer

Location

Loc Qty

Loc Code

GA

180

122063

180

ST260a

1536

m128401

6

m131026

80

m131697

50

m133134

600

m133284

500

m133316

300

st268

291

123900

7

m130388

86

m133077

198

NAS1149C0432R

Purchased

No

100

Each

1,116.000

2

2

NAS1149C0432R

133577

WASHER

DEC 15 2015

Location

Loc Qty

Loc Code

GA

889

m125807

428

m131467

461

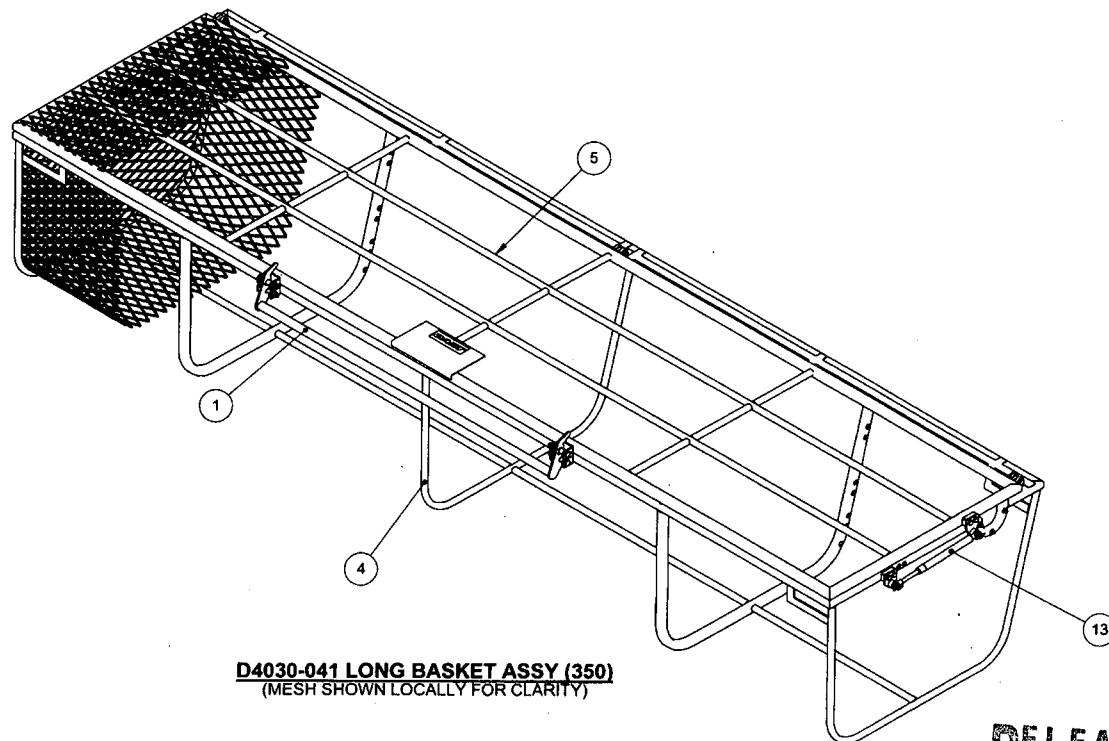
ST271

227

m131467

227

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4030-041	LONG BASKET ASSY (350)
1	1	D2530	HANDLE WELDMENT
2	2	D2535	SPRING
3	2	D2537	BUSHING
4	1	D3913-041	LONG BASKET BASE ASSY (350)
5	1	D3914-041	LONG BASKET LID ASSY (350)
6	6	D3917-3	WASHER
7	2	D3953-3	GAS SPRING STUD, LID
8	2	D3953-7	GAS SPRING SPACER
9	2	D3953-9	GAS SPRING WASHER
10	2	D3953-17	GAS SPRING SPACER
11	1	D3953-19	GAS SPRING BRACKET
12	1	D3953-21	GAS SPRING BRACKET
13	1	D3969-3	SPRING
14	4	AN3-14A	BOLT, MACHINE
15	2	AN3-16A	BOLT, MACHINE
16	3	AN4-12	BOLT, MACHINE
17	4	AN5-17A	BOLT, MACHINE
18	2	AN310C4	NUT, PLAIN, CASTELLATED
19	3	AN310-4	NUT, PLAIN, CASTELLATED
20	6	MS21042L3	NUT, SELF-LOCKING
21	4	MS21042L5	NUT, SELF-LOCKING
22	2	MS24665-300	COTTER PIN
23	3	MS24665-151	COTTER PIN
24	2	NAS1149C0432R	WASHER
25	6	NAS1149F0432P	WASHER
26	8	NAS1149F0332P	WASHER
27	4	NAS1149F0563P	WASHER



D4030-041 LONG BASKET ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
2013-08-16

120151006

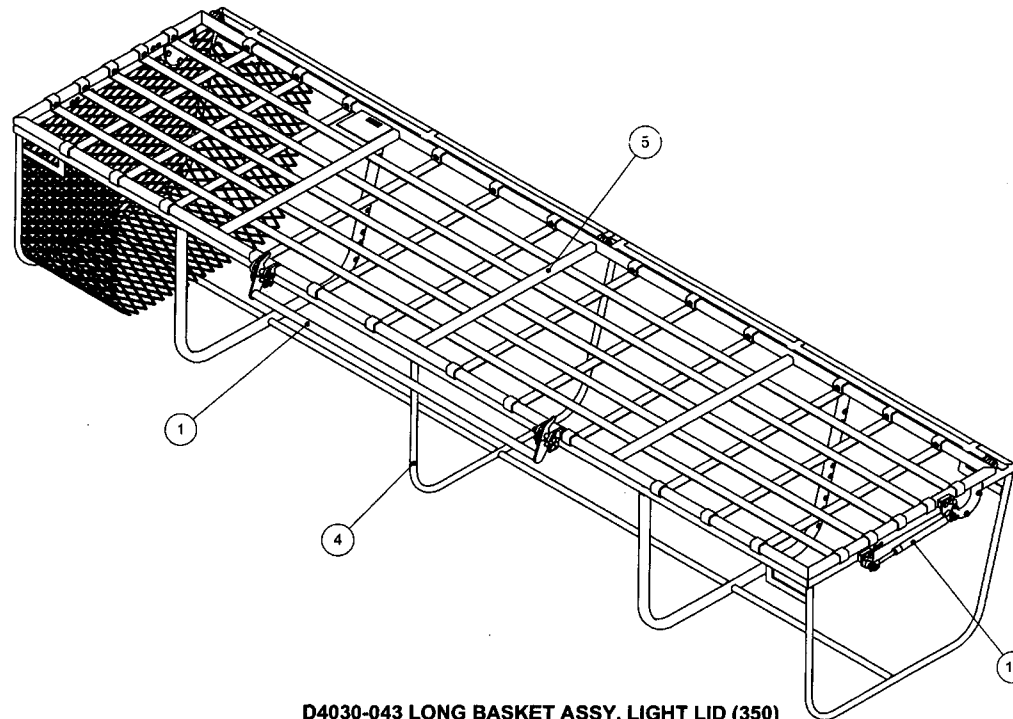
SH 137562

D	REFORMAT FOR CLARITY. PICTORIAL UPDATE TO MULTIPLE VIEWS DUE TO CHANGES IN SUB ASSEMBLIES.	AJS	13.07.18
C	QTY FOR ITEMS #30 & #31 UNDER -043 WERE MISSING (B8-1); QTY FOR ITEM #3 WAS 4 (D8-1). ONLY 2 ARE REQUIRED, AFFECTS SECTION C-C (D3-3).	MB	10.07.23
B	AN5-21A BOLT WAS AN5-19A: BOM & (D3-3)	JPH	10.04.08
A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D4030	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET ASSY (350)	NTS
DATE	13.07.18	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE REPRODUCED OR COPIED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 72 lbs APPROX

ITEM	QTY	P/N	DESCRIPTION
	X	D4030-043	LONG BASKET ASSY, LIGHT LID (350)
1	1	D2530	HANDLE WELDMENT
2	2	D2535	SPRING
3	2	D2537	BUSHING
4	1	D3913-041	LONG BASKET BASE ASSY (350)
5	1	D3915-041	LIGHT LID ASSY, LONG BASKET
6	6	D3917-3	WASHER
7	2	D3953-3	GAS SPRING STUD, LID
8	2	D3953-7	GAS SPRING SPACER
9	2	D3953-9	GAS SPRING WASHER
10	2	D3953-17	GAS SPRING SPACER
11	1	D3953-19	GAS SPRING BRACKET
12	1	D3953-21	GAS SPRING BRACKET
13	1	D3969-3	SPRING
14	4	AN3-14A	BOLT
15	2	AN3-20A	BOLT
16	3	AN4-12	BOLT
17	2	AN5-17A	BOLT
18	2	AN5-21A	BOLT
19	3	AN310-4	NUT, PLAIN, CASTELLATED
20	2	AN310C4	NUT, PLAIN, CASTELLATED
21	6	MS21042L3	NUT, SELF-LOCKING
22	4	MS21042L5	NUT, SELF-LOCKING
23	3	MS24665-151	COTTER PIN
24	2	MS24665-300	COTTER PIN
25	6	NAS1149F0432P	WASHER
26	4	NAS1149F0563P	WASHER
27	8	NAS1149F0332P	WASHER
28	2	NAS1149C0432R	WASHER



D4030-043 LONG BASKET ASSY, LIGHT LID (350)
(MESH SHOWN LOCALLY FOR CLARITY)

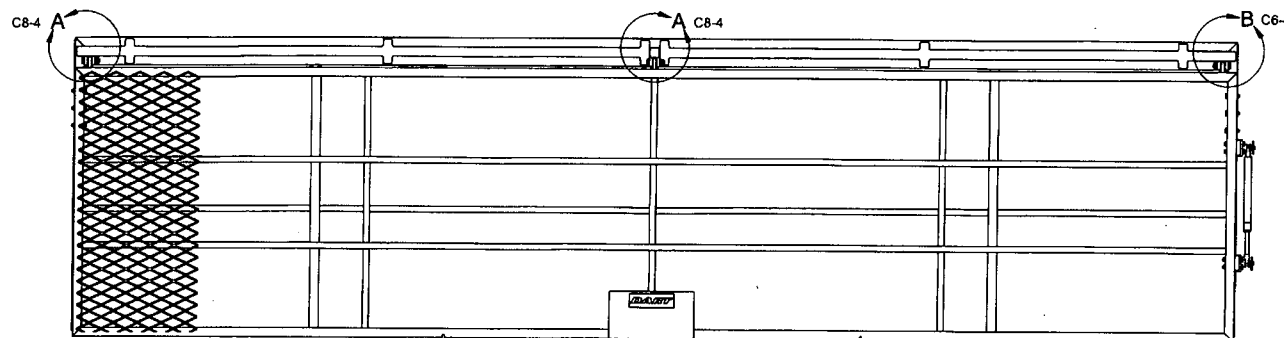
RELEASED
2013-08-16
MP

NOTES:

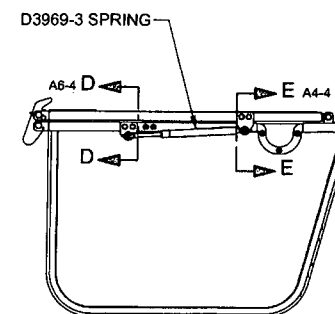
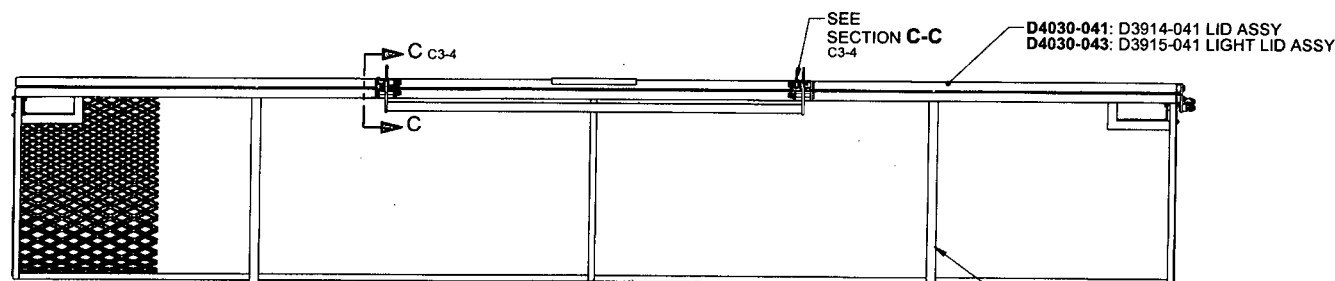
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 57 lbs APPROX

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. D
MFG. APPR.	<i>[Signature]</i>	D4030	SHEET 2 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	LONG BASKET ASSY (350)	NTS
DATE	13.07.18	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

RELEASED
2013-08-16



D2530
HANDLE WELDMENT



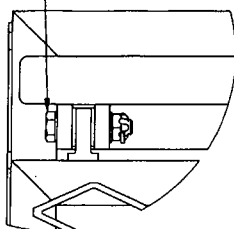
D4030-041 LONG BASKET ASSY (350) (SHOWN)
(MESH SHOWN LOCALLY OR REMOVED FOR CLARITY)

D4030-043 SHORT BASKET ASSY, LIGHT LID (350) (SIMILAR)
(MESH SHOWN LOCALLY OR REMOVED FOR CLARITY)

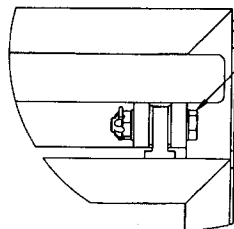
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DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. D
MFG. APPR.	<i>[Signature]</i>	D4030	SHEET 3 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	LONG BASKET ASSY (350)	NTS
DATE	13.07.18	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1

AN4-12 BOLT, MACHINE
D3917-3 WASHER, 2X
NAS1149F0432P WASHER, 2X
AN310-4 NUT, CASTELLATED
MS24665-151 COTTER PIN



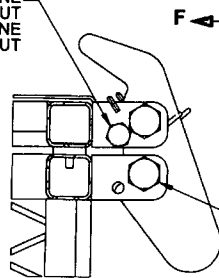
DETAIL A D8-3
D5-3



DETAIL B D3-3

AN4-12 BOLT, MACHINE
D3917-3 WASHER, 2X
NAS1149F0432P WASHER, 2X
AN310-4 NUT, CASTELLATED
MS24665-151 COTTER PIN

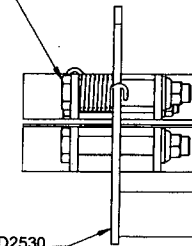
D4030-041: AN3-16A BOLT, MACHINE
MS21042L3 NUT
D4030-043: AN3-20A BOLT, MACHINE
MS21042L3 NUT



SECTION C-C B4-3
B6-3

D4030-041: AN5-17A BOLT, MACHINE
D2537 BUSHING
D2535 SPRING
NAS1149F0563P WASHER
MS21042L5 NUT
D4030-043: AN5-21A BOLT, MACHINE
D2537 BUSHING
D2535 SPRING
NAS1149F0563P WASHER
MS21042L5 NUT

AN5-17A BOLT, MACHINE
NAS1149F0563P WASHER
MS21042L5 NUT



D2530
HANDLE WELDMENT
REF

VIEW F-F C3-4

D3953-17 GAS SPRING SPACER
D3953-21 GAS SPRING BRACKET
AN3-14A BOLT, MACHINE
NAS1149F0332P WASHER, 2X
MS21042L3 NUT
2 PL

D3953-3 GAS SPRING STUD, LID
D3953-7 GAS SPRING SPACER
D3953-9 GAS SPRING SPACER
NAS1149C0432R WASHER
AN310C4 NUT, CASTELLATED
MS24665-300 COTTER PIN

D3969-3 SPRING
REF

SECTION D-D B2-3

D3953-17 GAS SPRING SPACER
D3953-19 GAS SPRING BRACKET
AN3-14A BOLT, MACHINE
NAS1149F0332P WASHER, 2X
MS21042L3 NUT
2 PL

D3953-3 GAS SPRING STUD, LID
D3953-7 GAS SPRING SPACER
D3953-9 GAS SPRING SPACER
NAS1149C0432R WASHER
AN310C4 NUT, CASTELLATED
MS24665-300 COTTER PIN

D3969-3 SPRING
REF

SECTION E-E B1-3

RELEASED
2013-08-16
AM

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO. D4030	REV. D SHEET 4 OF 4
MFG. APPR.	<i>[Signature]</i>	TITLE LONG BASKET ASSY (350)	SCALE NTS
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DE APPR.	<i>[Signature]</i>		
DATE	13.07.18		

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